

Dart Aerospace Ltd.

Date: Tuesday, 22/04/2008 12:36:20 PM
 User: Linda Lecelle

Process Sheet

Eagle # 44401

Customer	: CU-DAR001 Dart Helicopters Services				Drawing Name	: VERTICAL REFERENCE DOOR ASSEMBLY		
Job Number	: 37384				Part Number	: D412711011		
Estimate Number	: 10902				Drawing Number	: N/A		
P.O. Number	:				Project Number	: N/A		
This Issue	: 22/04/2008	S.O. No. :			Drawing Revision	: N/A		
Prsh't Rev.	: NC				Material	: N/A		
First Issue	: 12/02/2008	Type	: PURCHASED PARTS		Due Date	: 28/02/2008	Qty: 1 Um: Each	
Previous Run	: 37383							
Written By	:							
Checked & Approved By	:							
Comment	: Est Rev:A 04.08.18 New Issue KJ/DS							

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL
Comment: DOCUMENT CONTROL Photocopy bluefiles and create labels per PPP D412-711-011 CHG001		
2.0	PG	PURCHASING
Comment: PURCHASING Issue P/O: 5685 to Eagle Copters "Assembly of D412-711-011 Door Send a copy of this IPP		
3.0	D412711041	Vertical Reference Door Assembly
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Vertical Ref. Door Assy		
4.0	D412711101	Replacement Bubble Window
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)		
5.0	D412711111	Wiring Harness, 212/412
Comment: Qty.: 1.0000 Eagle(s)/Unit Total : 1.0000 Eagle(s) Pick: Packing Kit Qty Part Number Description Batch 1 D412-711-111 Wiring Harness, 212/412 <i>44500</i> <i>Apr 21/08</i>		

Page 1

JOB Number: 37384

Part Number: D412711011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0 CA20469-15412

Instrument Panel, 412



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 EA20469-15-412 Instrument Panel, 212/412

V6 44499

C221 Apr 24
08

7.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

EAGLE

Pick:Qty Part Number Description Batch

1 204-030-853-119 LH Co-pilot Door V6 44401

Attach serviceable tags

2- EAGLE

Fabricate/Pick the following parts to go into the door in accordance with:

D2046902 Sheet

1 Rev. 3

D2046902 Sheet 2 Rev. 2

D2046902 Sheet 3 Rev. 0

D2046901 Sheet 3 Rev. 1

Qty Part Number Description Batch

1	EB212-100L / EA20469-3	Window	<u>08-001222</u>
1	EA20469-05	Rubber Strip	<u>06-011664</u>
1	EA20469-06	Aluminum Strip	<u>Deleted</u>
1	EA20469-07	Angle	_____
1	EA20469-08	Placard	_____
1	EA20469-10	Rear Rib Assy	_____
1	EA20469-11	Angle	_____
1	EA20469-12	Fwd Rib	_____
1	EA20469-13	Window	_____
1	EA20469-14	Window Retainer	_____
1	CA20469-16	Armrest Assy	_____
1	EA20469-17	Angle	_____
1	EA20469-18	Door Inner Skin	_____
1	EA20469-21	Door Cover Panel	_____
2	EA20469-23	Link	_____
1	EA20469-24	Rod	_____
1	EA20469-25	Arm Assy	_____

W/44499

Material Certification / Proof of Traceability / Certificate of Conformity required

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Process Sheet

Drawing Name: VERTICAL REFFERENCE DOOR ASSEMBLY

Customer: CU-DAR001 Dart Helicopters Services

Part Number: D412711011

Job Number: 37384

Job Number:



Seq. #:	Machine Or Operation:	Description :
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3-EAGLE

Pick:

Qty	Part Number	Description	Batch
14	AN3-3ABolt	07-018790	
22	AN3-4ABolt	08-001209	
24	AN3-7ABolt	07-017476	
6	AN960-6L Washer	06-022623	
90	AN960-10L Washer	06-018522	
34	CR3242-4-2 Rivet	08-001645	
135	MS20426AD3-3 Rivet	07-006985	
140	MS20426AD4-3 Rivet	05-002460	
25	MS20470AD3-3 Rivet	07-007189	
90	MS20470AD4-3 Rivet	07-015056	
24	MS21042L3 Nut	08-002039	
2	MS21042L06 Nut	06-014775	
13	MS21069L3 Nut Plate	08-001202	
8	MS21069L08 Nut Plate	07-018940	
1	MS21071L3 Nut Plate	08-002216	
1	MS21071L08 Nut Plate	08-001935	
9	MS21075L3 Nut Plate	05-004764	
2	MS24677-12 Screw	05-011931	
6	MS27039-1-09 Screw	07-14232	

4-Assemble door in accordance with : D2046901 Sheet 2 Rev. 5 D2046901 Sheet 1 Rev. 5 Do not install EA20469-15 or wiring harness at this time.

5-Apply Dart P/N & B/N using fine point permanent marker

✓ Apr 21/08

8.0 QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: Eagle- INSPECT 100% KITS FOR COMPLETENESS

Send this W/O back to DartKit to be stocked at Eagle

GB

9.0 QCS

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

GB

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location:*Not Required - delivery to A/C.*

04/22/2008 22:08 613-632-1053

DART PRODUCTION

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Date: Tuesday, 22/04/2008 12:36:20 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL REFFERENCE DOOR ASSEMBLY

Job Number: 37384

Part Number: D412711011

Job Number:



Seq. #: Machine Or Operation:

Description :

11.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

1
D004/29

Job Completion



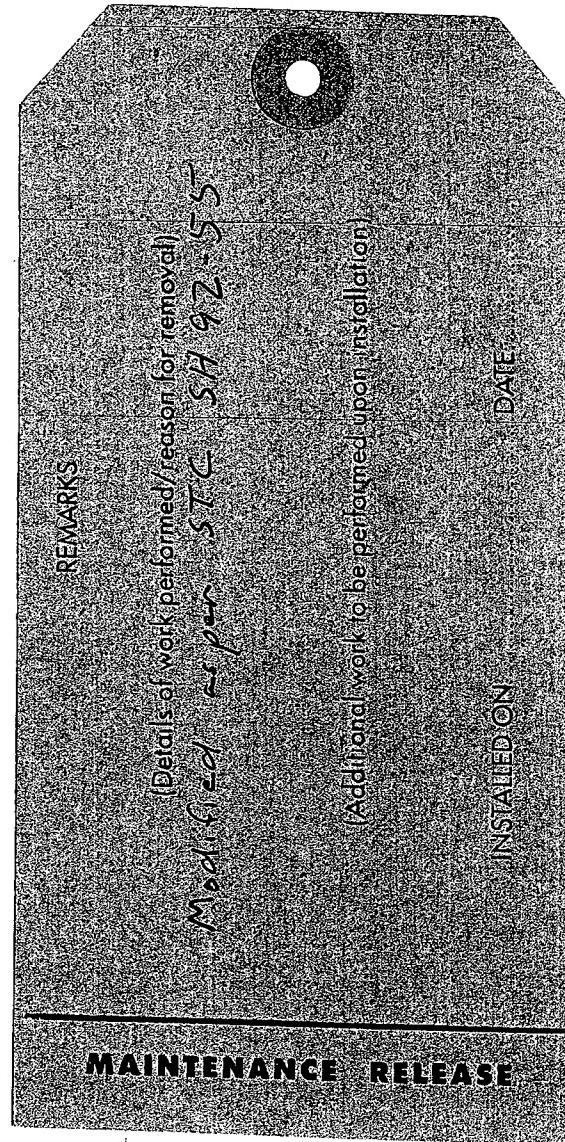
B/N 37384

O412-711-O41

EAGLE COPTERS MAINTENANCE LTD.	
322 MCFARLISH ROADNE CALGARY ALBERTA T2E 7G9	
DOT APPROVAL NO. 6-81	
Nomenclature	000-000-000-000
Manufacture	0
Part No	204-010-823
Location	5/2
ISO	1000
Inspected	<input type="checkbox"/>
Previous Configuration	2/2
The maintenance described has been performed in accordance with the applicable standards or airworthiness	
DATE	2/1/82
MAINTENANCE AUTHORIZED INSPECTOR	
Details of other maintenance work and other information	

REMARKS

MAINTENANCE RELEASE



Work Order Number: 44255 V/Door

This Work Report forms part of this aircraft's permanent technical records - DO NOT DESTROY.

Item: 1 L/H DOOR ASSEMBLY

Squawk: 1.1**Discrepancy:**

Modify to Vertical Reference Door

Resolution:

Modified Door to Vertical Reference Door as per STC No. SH92-55 on Service order P/O 07-003317. Door assembled as required.

1.1 Work Done By: Robbie Neyrinck***The maintenance described above has been performed in accordance with the applicable standards of airworthiness.*****AMO 6-81** Signature: Colin Gould on 4/22/2008**Parts:**

Part Number	Description	Lot Number	Condition	Qty
BELL212-L	BUBBLE WINDOW ILO EA20469-03 and D412-711-101	LT-08-001222	New	1

Outside Services:

Qty	Part Number	Serial Number	Part Description	Service Description
1	204-030-853-125		L/H DOOR ASSEMBLY	Modify

* End of Report *

***** Original Maintenance Releases and Independent Control Inspection details are stored electronically at *****
***** Eagle Copters Maintenance Ltd. in Calgary Alberta in the Corridor Software *****

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Estimate Number	: 10902			Drawing Number	: N/A		
P.O. Number	:			Project Number	: N/A		
This Issue	: 22/04/2008	S.O. No.	:	Drawing Revision	: N/A		
Prsht Rev.	: NC			Material	: N/A		
First Issue	: 12/02/2008	Type	: PURCHASED PARTS	Due Date	: 28/02/2008		
Previous Run	: 36802			Qty:	1	Um:	Each
Written By	:						
Checked & Approved By	:						
Comment	: Est Rev:A 04.08.18 New Issue KJ/DS						

Additional Product

Job Number:



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2.0	PG	PURCHASING	
Comment: PURCHASING Issue P/O: <u>5685</u> to Eagle Copters <u>C 408/02112(1)</u> "Assembly of D412-711-011 Door Send a copy of this IPP			
3.0	D412711041	Vertical Reference Door Assembly	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Vertical Ref. Door Assy			
4.0	D412711101	Replacement Bubble Window	
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Comment: Qty.: 1.0000 Eagle(s)/Unit Total : 1.0000 Eagle(s) Pick: Packing Kit Qty Part Number Description Batch 1 D412-711-111 Wiring Harness, 212/412			

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Job Number: 37383

Part Number: D412711011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0 EA2046915412

Instrument Panel, 412



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 EA20469-15-412 Instrument Panel, 212/412 _____

7.0 OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

EAGLE

Pick:Qty Part Number Description Batch

1 204-030-853-119 LH Co-pilot Door _____

Attach serviceable tags

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D2046902 Sheet 2 Rev. 2

D2046902 Sheet 3 Rev. 0

D2046901 Sheet 3 Rev. 1

Qty Part Number Description Batch

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1 EA20469-05 Rubber Strip _____

1 EA20469-06 Aluminum Strip _____

1 EA20469-07 Angle _____

1 EA20469-08 Placard _____

1 EA20469-10 Rear Rib Assy _____

1 EA20469-11 Angle _____

1 EA20469-12 Fwd Rib _____

1 EA20469-13 Window _____

1 EA20469-14 Window Retainer _____

1 EA20469-16 Armrest Assy _____

1 EA20469-17 Angle _____

1 EA20469-18 Door Inner Skin _____

1 EA20469-21 Door Cover Panel _____

2 EA20469-23 Link _____

1 EA20469-24 Rod _____

1 EA20469-25 Arm Assy _____

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24	AN3-7ABolt		
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25	MS20470AD3-3 Rivet		
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5-Apply Dart P/N & B/N using fine point permanent marker

8.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: Eagle- INSPECT 100% KITS FOR COMPLETENESS

Send this W/O back to DartKit to be stocked at Eagle

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL REFFERENCE DOOR ASSEMBLY

Job Number: 37383

Part Number: D412711011

Job Number:



Seq. #: Machine Or Operation:

Description :

11.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

